Work Order ID 91977 Page 1 October-19-12 12:46:56 PM Item ID: 647.1401 Accept *N900040100* Setup Start Revision ID: Item Name: Upper Cutter Assembly **Start Date:** 18/10/2012 Start Qty: 1.00 **Cust Item ID:** Required Date: 01/11/2012 Req'd Qty: 1.00 **Customer:** Reference: Run Process Plan: ML5 Date: 12-10-19 Tooling: Approvals: Date: Stop Date: SPC (Y/N): Date: Operation Sequence ID/ Set Up/ Reject Tool ID Tool # Plan Reject Accept Insp. **Work Center ID** Description **Run Hours** Code Qty Qty Number Stamp Draw Nbr **Revision Nbr** 647.1400 N/C 110 Pick Kit 0.00 AD 13-4-18 *110* Packaging 0.00 Memo Packaging 120 0.00 *120* Small Fab 0.00 Memo Small Fab Assemble as per dwg and apply loctite 598 on all mating surfaces per note 2. A/R LOCTITE 598: (25174 90-13-4-18 130 QC5- Inspect part completeness to step on W/O *130* QC Memo

Quality Control

											DQA:	Date:	
NCR: Y	'es /	No				WORK ORDER NON-O	CON	IFORI	MANCE / UP	DATE			
											QA Closed:	Date:	
Work Orde	r.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Orac	·'· —					Rework	7		Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	lo.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	lo	<u> </u>				Work Order Update]		Large Fab	Composite]	Supplier	
		T							· · · · · · · · · · · · · · · · · · ·		l c: 0	<u> </u>	
Root	ļ	ļ		1	-	ption of work order update	1	nitial		ction	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Chi	ief Eng	Desc	ription	Date	Verification	QC Inspector
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						F	AUL'	T CATE	GORY				
Landin	ng Gear	r				General							

Wrong Stock Pulled Crushed/Crimped. Burrs Instructions Incomplete/Unclear Part Lost/Missing Contamination Cuffs Maintenance Part Moved **Heat Treat** Countersink Mislabeled Positioned Wrong Other Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Drill Holes Offset Ripples in Bend Drawing Out of Calibration Torque Waves in Extrusion Turning Sequence Finish Out of Sequence Wave/Twist in Tube Folio Outside Dimensions

Grain

Hardware

Inspection Incomplete

Ovalized

Part Incorrect

Over/Under tolerance

Pressure/Forced

Weld

Temperature/Cure

Bending

Cracks

Centre Not Concentric to O/S

Bend

BOM/Route

Broken/Damaged

Quality Control

91977

Page 2

October-19-12 12:46:56 PM Item ID: 647.1401 Accept *N900040100* Setup Start **Revision ID:** Item Name: Upper Cutter Assembly *1* **Start Date:** 18/10/2012 Start Qty: 1.00 **Cust Item ID: Required Date:** 01/11/2012 **Req'd Qty:** 1.00 **Customer:** Reference: Run Process Plan: Date: Approvals: Tooling: Date: Date:_____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. Work Center ID Description Run Hours Code Qty Qty Number Stamp 140 Identify as per dwg & Stock Location *140* Packaging 0.00 Memo Packaging ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV*** 150 QC21- Final Inspection - Work Order Release 0.00 *150* QC 0.00 Memo

NOON 22.

DQA: _____ Date: ____

NCR:	Yes	1	No
IVCIV.	162	/	140

WORK ORDER NON-CONFORMANCE / UPDATE

										QA Closed:	Date	e:
Work Orde	r:				DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
Part N					Rework Scrap		ı	Skid-tube Machining	Crosstube Small Fab		Water Jet d. Eng. Coor.	Engineering Quality
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Root				Descri	ption of work order update	lni	tial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chie	f Eng	Desc	ription	Date	Verification	QC Inspector
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onapproved		1	11			AULT	CATE	GORY	•		<u> </u>	
Landin	g Gear				General							
-	Bending Centre No Cracks Crushed/		ntric to (o/s	Bend BOM/Route Broken/Damaged Burrs	Н		re on Incomplete ons Incomplete/	'Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi	ct	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
-	Cuffs Heat Trea	·			Contamination Countersink	\square		nance		Part Moved Positioned V		
	Inspection	n Strip in	Tube		Cut Too Short		1isread			Power Loss/	Surge [Other
	Ripples in				Drill Holes		ffset					
	Torque W	aves in E	xtrusior		Drawing		ut of C	alibration				
L	Turning S	equence			Finish		ut of S	equence				
1	Wave/Tw	ist in Tub	e	1	Folio	I lo	utside	Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

October-19-12 12:47:00 PM

Work Order ID: 91977

91977

Parent Item:

647.1401

647 1401

Parent Item Name: Upper Cutter Assembly

Start Date: 18/10/2012

Required Date: 01/11/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP REV:A 12.10.04 NEW ISSUE DD VERF-ILM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.9701		Manufactured	No		· • · · · · · · · · · · · · · · · · · ·		Each	0.0000		1			
646 9701 utter Sub Assembly	*			91	805				**		75 I	3 -4-	18
JAS1149FN832P		Purchased	No				Each	523.0000		6			
*NAS1149	FN832) *						-	**				
				Location		Loc (<u>Qtv</u>	Loc Code					
				275			198			·	_		
					122441		198		_		_		
				ST275			125				- a>	13-	4~18
					(115158)		125		_	6	_		
				ST294	100050		200				_		
S27039-08-19		n	M.		123352		200		_		-		
		Purchased	No				Each	600.0000		3			1
MS27039)-()8-19 *								**				···
				Location		Loc C	<u>Qty</u>	Loc Code					
		-		ST308			600		_		_		
					123352		600		_		- 4		
				12	4579					2	Æ	7 13~	4-18

										DQA:	Date:	
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						<u> </u>				QA Closed:	Date:	
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VVOIR OIG	CI					Rework]	Skid-tube	Crosstube		Water Jet	Engineering
Part I	No					Scrap		Machining	Small Fab		d. Eng. Coor.	Quality
						Use-as-is	Ther	moforming	Finishing	Rec/Sto	re/Packaging	Other
NCR I	No. —					Work Order Update]	Large Fab	Composite		Supplier	
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l	l IB	Bending			i	Bend	Grain		t t	Ovalized	ì	Pressure/Forced

Hardware

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Inspection Incomplete

Instructions Incomplete/Unclear

Over/Under tolerance

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Temperature/Cure

Wrong Stock Pulled

Weld

Other

BOM/Route

Contamination

Countersink

Cut Too Short Drill Holes

Drawing

Finish

Folio

Burrs

Broken/Damaged

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Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Cracks

Cuffs

Heat Treat

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Centre Not Concentric to O/S

October-19-12 12:47:00 PM

Work Order ID: 91977

91977

Parent Item:

647.1401

647 1401

Parent Item Name: Upper Cutter Assembly

Start Date: 18/10/2012

**

Required Date: 01/11/2012

Start Oty: 1.00

Required Qty: 1.00

MS21042L08

Purchased

No

Each

1,234.000

MS21042L08

Locatio	<u>on</u>	Loc Qty	Loc
315	123900	47	
	122452 .	47	
ST315		500	
	122814	500	
ST317		687	
	122141	687	

c Code

3 15-4-18

647.1510

Manufactured No

Each

0.0000

**

647 1510

Upper Deflector

125082

										DQA	۸: Da	ate: _	
NCR:	Yes / No				WORK ORDER NON-O	CON	IFORM	MANCE / UPI	DATE				
										QA Close	d: Da	ate:	
Work Orde	or:				DISPOSITION				AGAINST D	EPARTMEN	T/PROCESS		
WOIK OIGE					Rework	7		Skid-tube	Crosstube	1	Water Je	r	Engineering
Part N	Vο				Scrap			Machining	Small Fab	- _{Pı}	od. Eng. Coor	\vdash	Quality
					Use-as-is	1 1		noforming	Finishing		ore/Packaging	-	Other
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	Cracks	.		<u> </u>	Broken/Damaged	\vdash	· ·	on Incomplete	, , 	Part Incore			Weld
	Crushed/	'Crimped			Burrs	\vdash		ions Incomplete/l	unciear	Part Lost/I	_	Ш	Wrong Stock Pulled
	Cuffs			1	Contamination		Mainte	nance		Part Move	О		

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

	ENGINEERING CHANGE NOTICE NO. 02962 SHEET 1 OF 1
APICAL	DWG NO. 647.1400 REV: N/C BY R. ROSANO DATE: 09/01/10 EFFECT ON DWG R. ROSANO DATE: 09/01/10 INC. WILLIAM
INDUSTRIES, INC.	DWG TITLE: CUTTER ASSY
	APPROVED BY: ENGR From MFG Dun Pour Pour CURRENT ORDER
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON: REPLACED CUTTER BODY IN 647.1401

STOP COPY
RETURN TO
SINGERING
ONTROLLED COPY
FOR TO AMENIMENT
WITHOUT NOTICE
WORK ORDER
1977 MCJ

8	Α	648.3601		1	CUTTER SUB	ASSY					
1	R	646.9701	1		CUTTER SUB	ASSY				, , , , , , , , , , , , , , , , , , , ,	
-/N	TC	PART NUMBER	JMBER 1402.1401 DESCRIPTION							AL	SPECIFICATION
DOC	UM	ENTS EFFECTED:			□ INSTALL INSTRUC	☐ ICA	⊠ BOM □	HANGE (CATEGORY MINOR	DER RE	VIEW REQUIRED

